

Date: Tuesday, 4/17/2007 3:09:13 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CYCLIC STICK
Job Number : 31943	
Estimate Number : 12832	
P.O. Number : N/A	Part Number : G10202
This Issue : 4/17/2007 S.O. No. : N/A	Drawing Number : G10202 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : A
Previous Run : N/A	Material : N/A
	Due Date : 4/20/2007
Written By : _____	Qty: 1 Um: Each
Checked & Approved By : <u>07.04.17</u>	
Comment : Est Rev:A New Issue 07-04-16 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR1125W065	304 RD Tube 1.125 x .065w
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Comment: Qty.: 2.6250 f(s)/Unit Total : 2.6250 f(s)  
 304 RD Tube 1.125 x .065w  
 Batch: 104034

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1  
 Form ,Cut as per Dwg G10202.

18020417 PTO

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

07/04/18 (1)

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1  
 Weld assembly as per dwg G10202.  
 A/R SS Rod Batch: M102756

PD 07-04-18 (1)

5.0	QC5/9	WELD INSPECTION
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Comment: WELD INSPECTION

07/04/18 (1)

6.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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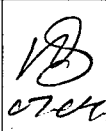
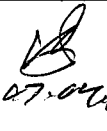

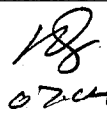


Comment: CONVENTIONAL MILLING MACHINE  
 Drill as per Dwg.

PD 07/04/18 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes (No) DQA: DP Date: 07/10/13  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
	2	36" scraped M04 V34	 aspen	new design	 07/06/17	 07/06/17	 aspen	 07/06/17

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CYCLIC STICK

Job Number: 31943

Part Number: G10202

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC5

INSPECT WORK TO CURRENT STEP



*For 04-18 @*



Comment: INSPECT WORK TO CURRENT STEP

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*CP 04/04/18 @*

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*04/04/18*

Job Completion



*u 07-04-18*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

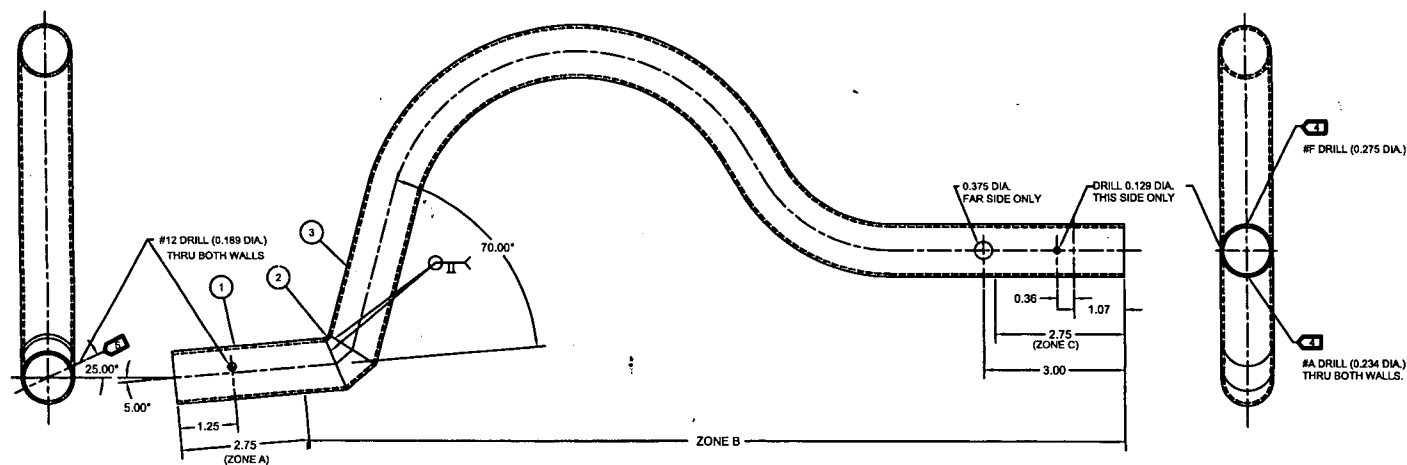
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

REVISIONS		
REV	DESCRIPTION	APPROVAL DATE
A	REDRAWN IN CAD	5/30/03 CLB



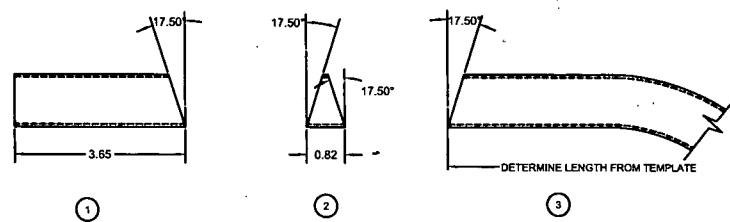
DETAIL -1

ZONE	TOLERANCE
A	±.050
B	±.300
C	±.050


NOTES: 1 DEBURR ALL SHARP EDGES.

- D DRILL 0.234 DIA. THRU BOTH WALLS. THEN DRILL 0.257 THRU ONE WALL AS SHOWN.
- D DRILL 0.189 DIA. THRU BOTH WALLS. AT 25° OFF HORIZONTAL AXIS AS SHOWN.

OPTIONAL: TEXT MAY BE ENGRAVED, STAMPED OR PRINTED ON PART AS DESIRED



NO. 31943  
 WORK ORDER  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 UNCONTROLLED COPY  
 ENGINEERING  
 RETURN TO  
 SHOP COPY

1	-1	1.125 O.D. : .050 TO .070 WALL	304 STAINLESS TUBING
QTY	DASH	DESCRIPTION	MATERIAL
BREAK SHARP EDGES UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	125	DESIGNED CLB	DATE 5/30/03
TOLERANCES ARE: FRACTIONS DECIMAL ANGLES 1/16" .005 1/2° 1/32" .002 1/4° 1/64" .001 1/8°		DRAWN DATE	
		CHECKED DATE	
		APPROVED GLH	DATE 5/30/03
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Drawing Number G10202			REV A
Part No: GA122			SIZE B Scale: 1:1 Sheet 1 of 1